

Date: Tuesday, 12/20/2005 3:37:01 PM
 User: Kim Johnston

Process Sheet

| | | | |
|----------------------------------|--|-------------------------|-----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : LATCH BRACKET |
| Job Number | : 25326 | | |
| Estimate Number | : 10994 | | |
| P.O. Number | : N/A | Part Number | : D2583 |
| This Issue | : 12/20/2005 | S.O. No. | : N/A |
| Prsht Rev. | : NC | Drawing Number | : D2583 REV. B |
| First Issue | : 12/20/2005 | Project Number | : N/A |
| Previous Run | : N/A | Drawing Revision | : B |
| | Type : MACHINED PARTS | Material | : N/A |
| Written By | : HAAS <u>SEE COMMENT BELOW</u> | Due Date | : 1/15/2006 |
| Checked & Approved By | : <u>SEE ABOVE USER</u> | Qty: | 100 |
| Comment | : Est: C 00.11.01 Removed P/O for Powder, Coat- in house processDM | Um: | Each |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|--------------|---------------------|
| 1.0 | M5052H32S040 | 5052-H32 .040 Sheet |
|-----|--------------|---------------------|



Comment: Qty.: 0.1227 sf(s)/Unit Total: 12.2745 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.040" thick
 (M5052H32S040)

Batch: M17835

| | | |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|



Comment: SHEAR

Cut blank: 4.000" x 2.130"

Grain offset 10° along 3.188"

JL 06.01.08 100

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2583

JL 06.01.08 100

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 06.01.08 100

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE

Deburr

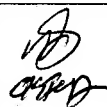


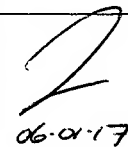
Form on CNC Brake as per Dwg D2583

JB 06/01/17 98

DL 06/01/13 100

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/24
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--------------------------------------|---|---------------------------------|----------------|--|---|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06/01/17 | 5 | 1 piece was bend out of tolerance |  | Scrap & destroy | SB 06/01/17 |  06-01-17 |  |  06-01-17 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 3:37:02 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH BRACKET

Job Number: 25326

Part Number: D2583

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06:01:21 99

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m. 06-02-23

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MA 06 02 23 99

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5189

06/02/23 99

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/02/24

Job Completion



u. 060224

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

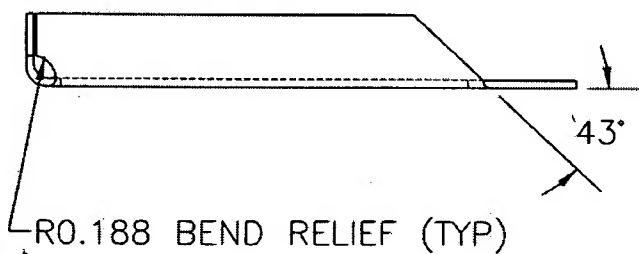
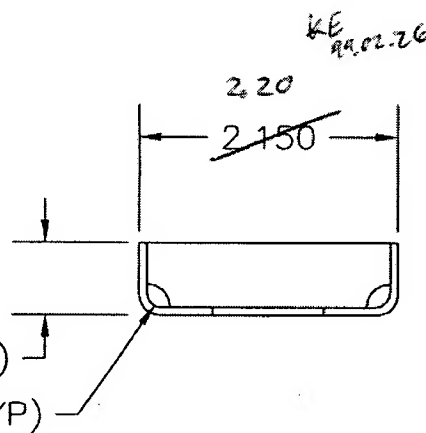
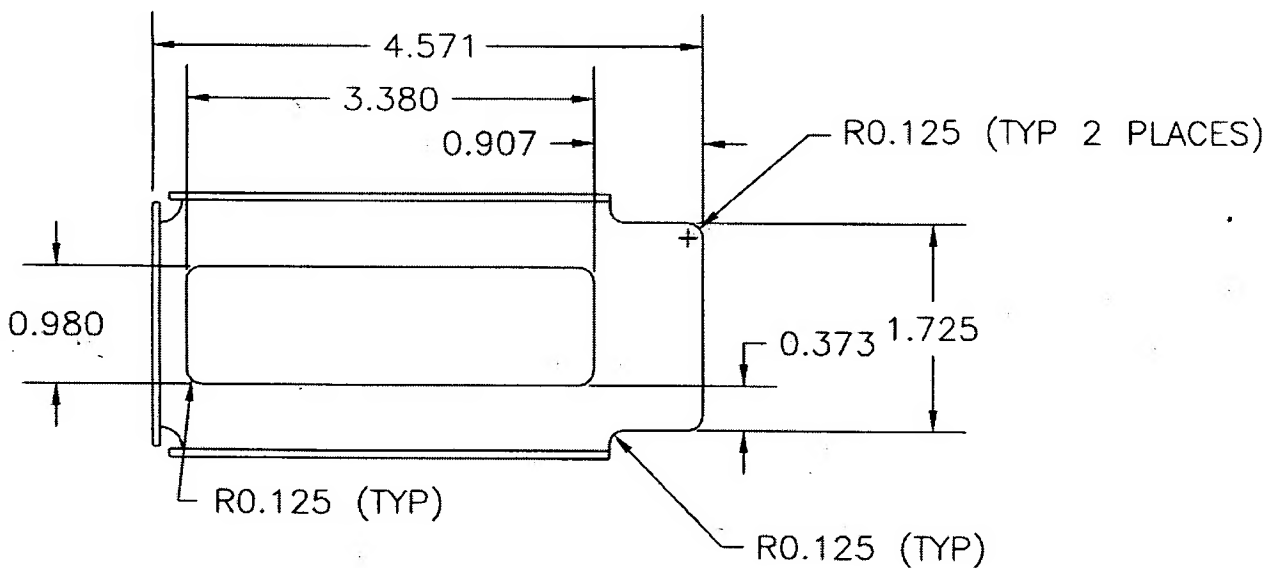
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



DART**RELEASED**
KE 99.02.25

| DESIGN | DRAWN BY | DART AEROSPACE LTD | REV. B |
|----------|---------------|---------------------------------|--------------|
| MIKE M. | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | SHEET 1 OF 1 |
| CP | KE | D2583 | |
| DATE | TITLE | | SCALE |
| 99.02.22 | LATCH BRACKET | | 2:3 |
| A | 96.07.10 | NEW ISSUE | |
| B | 99.02.22 | CHANGE OF FINISH (PER TSR A887) | |



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED